RESEARCH AND DEVELOPMENT, NEUCHATEL - QUARTERLY REPORT

DIVISION : QUALITY ASSURANCE

SUBJECT TITLE : SUBJECTIVE CIGARETTE EVALUATION

PERIOD COVERED : APRIL - JUNE 1990

WRITTEN BY : MONNIN E. (EMO)

KEYWORDS : panel, discriminative, consumer, test, project, monitoring, assistance

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DISCRIMINATIVE PANEL

Sixteen tests were carried out by the R&D Panel B during April, May and June 90 using the DDD-method (PME-method no. 720). No significant difference was detected between the control and the experimental cigarette in 13 tests. A significant difference was reported in 3 tests.

Classification of the tests by type of modification :

Tow	5 tests
Cigarette paper	3 tests
ESP- Perforation	2 tests
Ingredients	2 tests
Collaborative tests	2 tests
Glue	1 test
Filter paper	1 test

CONSUMER PANEL

Test C2 90 109

A consumer test using the standard comparison questionnaire was carried out in February at the request of the R&D Manufacturing Services Group (MSG). The purpose of the test was to qualify the tow ex Courtauld on MLK cigarettes. Results obtained revealed that the cigarettes were not perceived as significantly different. (1)

Test C1 90 110

A consumer test requested by the R&D MSG was launched in mid-May. The objective was to replace ingredients MPEG 550, MPEG 750 and PEG 600 by triacetine as well as to qualify the tow Rhodia (Project "Carbo") on Brunette Double Filter cigarettes. The report will be issued beginning of July.

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

Test C3 90 111

R&D MSG requested a consumer test for the same reasons as for test C1 90 110 on Muratti Ambassador cigarettes. The test was launched in mid-May. The report will be issued beginning of July.

PROJECT PANEL MONITORING

Methodology

Following the decisions taken in the panel-leaders'meeting (PALEM) in Neuchâtel in January 90, a smoking evaluation session was held in Lausanne 11th April (2). Panel A, local Leaf experts and some QA people participated in this panel session.

The objective was to evaluate the degree of difference between a control cigarette and a prototype using the 1 to 7 point scale. This was repeated for each of the five prototypes produced with this aim in Neuchâtel. The experts also gave a description of each experimental cigarette. These two parameters should help the B-panelists to become more self-confident when evaluating the difference between two cigarettes.

It was also decided that each prototype produced for the collaborative tests, together with the associated reference cigarette, would also be submitted to the consumer panel. Results from the consumer panel ought to give a threshold of discrimination to be achieved by our internal B-panels. Indeed, we expect from our panels that they be at least as discriminative and preferably somewhat more, so than the regular consumers of our brands.

Collaborative Test no 8

This test was the first using the training procedure developed during the PALEM meeting in Neuchâtel. The cigarettes submitted were PMU vs PMU with PMS blend.

See table of results obtained :

Panel 1 : S
Panel 2 : S
Panel 3 : NS
Panel 4 : NS
Panel 5 : S

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The expected result for this test was : significant difference. Three panels performed acceptably, two panels need to improve. However, one should pay attention to the fact that the cigarettes used for this round of tests are ultra low-tar products. These characteristics caused in fact two problems i) the difficulty to evaluate the difference between two such products because they do not have much taste ii) for the latter reason, the PMU are generally not appreciated by the panelists.

Report on collaborative test no. 8 is under way.

Consumer test C4 90 112

This consumer test was initiated by the R&D Panel Testing Group at the end of May. The cigarettes submitted were standard MLZ vs MLZ with MAA cut filler. This prototype was subjected to the European B-panels in June as collaborative test no. 9. Results of the consumer test will be available in August.

Consumer test C2 90 113

This consumer test was initiated by the R&D Panel Testing Group at the end of June. The products tested were standard MLK vs MLK without after cut. This prototype will be submitted to the European B-Panels as collaborative test no. 10 in August. Results of the consumer test will be available in mid-August.

ASSISTANCE TO ITALY

A visit was paid to the Bologna factory on 15th May. The purpose was to discuss the feasibility of carrying on the training of the Bologna panel this year. The panel leader had to refer to the MONITAL Management for the decision.

The project is pending.

REFERENCES

(1) Report on consumer test C2 90 109 by Monnin-E., dd April 9, 1990.

(2) Minutes of the smoking evaluation session by Monnin-E., dd May 8, 1990.

E. Monnin

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

RESEARCH AND DEVELOPMENT, NEUCHATEL - QUARTERLY REPORT

DIVISION	:	QUALITY ASSURANCE + TECHNICAL SERVICES
SUBJECT TITLE	:	INFESTATION CONTROL
PERIOD COVERED	:	APRIL - JUNE 1990
WRITTEN BY	:	Freymond-J.M. (JMF)
KEYWORDS	:	FTR, Infestation control, DIANEX, dust, samples, MTI, program, manual, Rome, Verona, presentation, Papastratos, visits.

INFESTATION CONTROL IN FTR

Objective

Ensure that the new program including DIANEX application is properly implemented in FTR.

Status

During this period, only 12 cigarette beetles were captured on pheromone traps installed in the factory. This shows that the cleaning program and DIANEX applications act effectively in keeping insect population at a low level.

One DIANEX application was made in May. Tobacco dust samples are being collected in the factory, at random, every two months. One sampling was made in February, another one in May. All samples were analysed for their methoprene (DIANEX active ingredient) residue concentrations. Methoprene residues, in each sample, were higher than the lowest efficacy limit of 1 ppm. Detailed results are available (1, 2).

Plan

Carry on with the next sampling and DIANEX application according to the following schedule:

July, week 28 : tobacco dust sampling
August, week 33 : DIANEX application
September, week 37 : tobacco dust sampling

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

VISIT TO MTI DIRECTION IN ROME

Objective

- Present the PM Infestation Control program to the Direction of the Italian Tobacco Monopoly.

- Obtain MTI agreement to implement our program in the factories of PM cigarette production.

Status

A presentation of the program was made to the MTI Direction in Rome on May 17, 1990 and was well received. Afterwards, it was agreed that PME R&D would proceed to the implementation of the program in the factories of Verona, Bologna, Rovereto and Florence.

Plan

Implement the PM Infestation Control program in the factories (above) of PM cigarette production, starting with Verona. Review and distribute the Manual (by hand) to each local pest-control operator with proper training, during respective visits (to be scheduled).

VISIT TO PAPASTRATOS FACTORY/WAREHOUSES IN GREECE

Objective

- Review the current Infestation Control practices

- Implement the PM Infestation Control program.

Status

From May 28 to June 1, a visit was paid to the Papastratos factory/warehouse, where Marlboro under-licence production is made. A presentation of the Infestation Control program was made to the key Papastratos personnel. The presentation was well received.

Also, a complete sanitary inspection and distribution -marking- of pheromone trap positions were made in the Agrinion warehouses and the factory's Primary, Secondary and tobacco stores. Proper recommendations were made in a report (3).

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

Plan

Organize a follow-up visit to Papastratos by mid-1991, together with a PM-USA R&D entomologist to distribute the PM Infestation Control Manual (by hand) to the local Pest Control Operator, and review the program.

VISIT TO MTI FACTORY IN VERONA, ITALY

Objective

- Review the current Infestation Control practices

- Implement the PM Infestation Control program.

Status

On June 26-29, 1990, a visit was paid to the MTI factory of Verona, where DIANA (DIS, DIK) cigarettes -under PM licence- are produced.

A presentation of the Infestation Control program was made to the key personnel of Verona factory, the warehouse Managers of Bologna, Rovereto and Florence, and the QC and Infestation Control Managers of Chiaravalle factory (possible future PM production site). The presentation was well received.
A complete sanitary inspection and pheromone-trap distribution (marking on factory maps) were made.
Proper recommentations were made. A report is being issued.

Plan

Organize a follow-up visit by mid-1991 to review/distribute (by hand) the PM Infestation Control Manual, with proper training, to the local pest-control operator.

References

1. Letter from D. Amati to J.-M. Freymond, FREY17/1QRT90
2. Letter from D. Amati to J.-M. Freymond, FREY18/2QRT90
3. Visit report, vis9021.jmf

July 12, 1990/JMF/vep
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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

DIVISION : QUALITY ASSURANCE + TECHNICAL SERVICES

SUBJECT TITLE : QUALITY ENGINEERING

PERIOD COVERED : APRIL - JUNE 1990

WRITTEN BY : Henry-P. (HEP), Morelli-M. (MMO)

KEYWORDS : handbook, visual, quality, audit, pme, methods, audio-visual, qa, volga, aging, finished product, automatic, tobacco, remover, actor, pack, seal, efficiency, imps.

HANDBOOK FOR VISUAL QUALITY AUDIT OF FINISHED PRODUCTS

Objective

Develop a revised Handbook of Visual Standards for Finished Products jointly with PM-USA. Implementation of the new procedure at PME-QA is planned for January 1st, 1991.

Status

Packaging standards

PM-USA sent to PME in April 1990 the 250 completed manuals of Packaging Quality Standards.

Cigarettes standards

- Final agreement was reached regarding cigarette standards between PME and PM-USA. Comments received from the US factories and from the VQA-PME laboratory with practical experience have been taken into consideration.
- PM-USA has sent the "Generic" cigarette illustrations, and positive comments were made by PME.
- PME has developed a proposal of new weighting factors including documentation explaining how they were set up.
- PME has developed a draft of the inspection procedure including soft pack, hard pack and cigarette.

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

Plans

- Develop the EDP application, i.e. data base, sample management and monthly report.

- Submit the proposal of the new weighting factors to the affiliates as well as to PM-USA.

- Proofread the "Good to print" of the cigarette standards (French, Italian, German and Dutch).

- Finalize the inspection procedure and make the translation in French.

- Develop a cigarette support and adapt it to new inspection procedure in order that the auditors eliminate handling cigarettes as much as possible.

PME METHODS MANUAL

Status

Several finalized methods were sent to the holders of a complete manual and reference documents from Manufacturing Services Group were also introduced in the system:

- no 026: laminar test of cigarette papers using ratio-R calculation

- no 056: determination of the capability line of filtration material

- no 771: final inspection report for non-tobacco materials to be used by suppliers

- no 820: guidelines regarding PME specifications for casings and flavor

- no 821: guidelines for producing casings and flavors

- no 822: guidelines for checking casings and flavors

- no 823: guidelines for the ingredient tests to be run before registration in the "usage catalogue".

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

AUTOMATIC TOBACCO REMOVER

Objective

Develop an efficient method to recover tobacco from finished cigarettes for further analyses such as cylinder-volume and sieve-size distribution.

Status

The series of 8 devices is currently being manufactured by an outside company in Berlin.

Plan

All devices will be tested before delivery, which is expected to take place by September/October 1990.

CHECKING OF AGED FINISHED PRODUCT

Objective

Develop regional guidelines on how to check aged finished product in affiliates' warehouses in order to have application of standardized rules.

Status

After having taken inventory of current, regional procedures, a draft proposal was sent to the QA managers, PM-EEC and PM-EEMA. We expect comments by August 24th, 2021608577 1990.

Plan

This subject will be finalized during the next QA managers meeting in BOZ in September 1990.

Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

REGIONAL PACK SEAL EFFICIENCY SURVEY

Objective

Carry out a survey in all factories regarding pack-seal efficiency using IMPS tester in order to have a consistant baseline for further discussions and to set objectives.

Status

A sampling plan has been sent to the factories, proposing to test 12 groups in each factory.

Plan

Results will be consolidated in Neuchâtel and presented at the next QA managers meeting in BOZ in September 1990. The deadline to send results is August 31st, 1990.

PROJECT VOLGA

Objective

Install a QA system in Kuibyshev including QA instruments and QA procedures.

Status

A list of QA equipment including price estimates has been prepared and handed over to AOD EEMA.

Plan

Orders will be placed by FTR as soon as we get the green light from AOD EEMA.

July 13, 1990/HEP/vep
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Morelli

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

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MANUFACT. SERVICES

Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

DIVISION	:	MANUFACTURING SERVICES GROUP
SUBJECT TITLE	:	INGREDIENTS, CASINGS & FLAVORS
PERIOD COVERED	:	APRIL - JUNE 1990
WRITTEN BY	:	Schwarb-A. (ADS)
KEYWORDS	:	ingredient, casing, flavor, prototype, trial, reformulation, evaluation, standardization, guidelines, methods

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1. INGREDIENTS

1.1 Guidelines - Methods (Refs. 1 to 4)

R&D decided that documents such as the Guidelines are to be included in the official book of PME Methods.

Four Guidelines were reviewed, updated and issued as new PME Methods :

1. PME Method No. 820
   Guidelines regarding PME Specifications for casings and flavors
   (Issue No. 2, dated May 11, 1990).

2. PME Method No. 821
   Guidelines for producing casings and flavors
   (Issue No. 4, dated June 20, 1990).

3. PME Method No. 822
   Guidelines for checking casings and flavors
   (Issue No. 4, dated June 21, 1990).

4. PME Method No. 823
   Guidelines for the ingredient tests to be run before registration in the usage catalogues
   (Issue No. 4, dated June 22, 1990).

1.2 Usage catalogues (Refs. 5 and 6)

Updated versions of "Usage of Ingredients" and "Usage of filter additives" were issued on June 29, 1990. In these documents there is a mention of trade name and/or article number per goods and per supplier. When already issued, Material Specifications (MS Nr.) are also given per supplier, and a reference to the PM Technical Sheet is made per item.

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

1.3 Ingredient Specifications - PM Technical Sheet (Ref. 7)

PM Technical Sheets for 8 of the most sensitive ingredients (humectants, cocoa products, licorices and triacetin) were issued and sent to QA of PME Affiliates. A table of the critical parameters to be controlled as Incoming Inspection of these ingredients was attached.

1.4 Material Specifications (Ref. 8)

Material Specifications (33) were issued and submitted to suppliers for signatures concerning all goods for which PM Technical Sheets were issued. Duly signed documents and/or comments concerning these Material Specifications are being collected by HQ Purchasing. A synthesis of the supplier's comments will be made and a final version of Material Specifications will be sent to suppliers by the end of September 1990.

1.5 Cochise / PME Code 10.1250

Project ALUNITE No. 5036 - Trial No. 3 (Ref. 9)

The Cochise (ground cocoa shells) from NEAL, Bremen, West Germany was tested in order to find a second European source for this ingredient (alternative to the product from Thoresen).
No significant difference in taste response was detected by Panel A.
The follow-up of this project is to organize an industrial trial at FTR, and if results are positive, to request PMG and PMH to have local confirmation test made.

1.6 Ethanol denatured PME code 10.2880

Project APATITE No. 5043 - Trial No. 2 (Ref. 10)

This trial is the repetition on an industrial scale of trial No. 1, to prove whether our product quality will be maintained, using MEK (methyl ethyl ketone) as denaturant instead of methanol and Bitrex.

Leaf experts PM EEC & EEMA found a taste difference and therefore they do not recommend implementing MEK as an alcohol denaturant within PME.

The denaturation of alcohol within Philip Morris will be reviewed with PM USA flavor specialists early July during my visit to Richmond.

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1.7 Burley Process Standardization within PME Affiliates (Ref. 11)

The undersigned collaborates in R&D New Process Development projects for all questions related to casings (formulation, preparation and application).
The specifications concerning the concentrated Burley Spray solution to be used for PMU blends will be reviewed with PM USA flavor specialists during my visit early July. These specifications will be transmitted to R&D New Process Development, Mr. R. Wagoner, project leader in charge of the Burley Capacity Increase Study at PMG.

Concerning FTR, no actions are planned until the existing equipment is improved/replaced.

1.8 PMS-AC PME Code 12.2135 (Ref. 12)

Following a complaint from PMH re stability problems with the above-mentioned aftercut, a study was initiated within R&D. A proposal to modify this casing formulation was sent to PM-USA flavor specialists. PM USA proposed a different modification of the existing aftercut recipe, by adding some propylene glycol. According to German legislation, the maximum level of humectants must be below 5 %.
Therefore this change cannot be implemented as such.
This new aftercut recipe was given to R&D New Product Development to be included in a trial series of BEAR project together with other standardization proposals of casings and flavors. Results of these tests are expected by the end of August 1990.

2. ASSISTANCE TO PME AFFILIATES AND LICENSEES

2.1 Flavor Drums ex-PM Richmond

R&D proposed reducing the large number of labels and stickers put on a flavor drum. This proposal is currently being studied by Flavor Specialists and legal entities at PM-USA. Richmond basically agrees with our proposal and is currently investigating the purchase of printing equipment driven by a computer. The target is to get a sticker generated by the computer with all the necessary information directly at the PM USA Flavor Center. This sticker will then be put on each drum before it leaves Richmond. This should be finalized very soon.

2.2 FTR - Swiss Customs Requirements (Ref. 13)

R&D answered a request from the Swiss customs concerning PM Flavor 153, to ease up logistics when importing this flavor.

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

2.3 PME - Shelf life of base flavors (Ref. 14)

During the reported period, R&D had to intervene several times because of shelf-life-related problems. It happens very often that orders of base flavors from PM USA are delayed or that they must be used after arrival within a very short time (even 15 days). This subject will be reviewed with PM USA Flavor Specialists during my visit early July, and we will try to issue a procedure to ease logistics.

REFERENCES

1) A. Schwarb "PME Methods Manual - Guidelines regarding PME Specifications for casings & flavors" Issue No. 2 dated June 19 and May 11, 1990.

2) A. Schwarb, "PME Methods Manual - Guidelines for producing casings and flavors", Issue No. 4 dated June 20, 1990.

3) A. Schwarb, "PME Methods Manual - Guidelines for checking casings and flavors ", Issue No. 4 dated June 21, 1990.

4) A. Schwarb, "PME Methods Manual - Guidelines for the ingredient tests to be run before registration in the usage catalogues ", Issue No. 4 dated June 22, 1990.

5) A. Schwarb, "Usage of Ingredients" dated June 29, 1990.

6) A. Schwarb, "Usage of Filter Additives" of June 29, 1990.

7) A. Schwarb, "Ingredient Specifications" dated April 27, 1990.

8) Memos from A. Schwarb to Mr. A. Peier dated May 14 and June 22, 1990 "Material Specifications".

9) Final report "Project Alunite No. 5036 - Trial No.3" from A. Schwarb dated June 14, 1990.

10) Final report "Project Apatite No. 5043 - Trial No.2" from A. Schwarb dated June 14, 1990.

11) Memo from A. Schwarb to Mr. R. Wagoner dated July 18, 1990 "Burley Capacity Increase at PMG for PMU PM021-25".

12) Memo " Proposition to modify solution PMS - AC (12.2135) " from A. Schwarb dated February 23, 1990 to Mr. E. Cook.

13) A. Schwarb, "Dédouannement provisoire No. 1130/207668 du 02.05.1990" dated May 21, 1990.

14) Profs note "Shelf life of base flavors" from A. Schwarb to QA and Purchasing of FTR,PMG and PMH, dated May 14, 1990.

ADS/July 19, 1990
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A. Schwarb

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RESEARCH AND DEVELOPMENT, NEUCHATEL - QUARTERLY REPORT

DIVISION : MANUFACTURING SERVICES GROUP

SUBJECT TITLE : NON-TOBACCO MATERIALS EVALUATION

PERIOD COVERED : APRIL-JUNE 1990

WRITTEN BY : Bel-T. (THB)

KEYWORDS : material, filter, additive, charcoal, tow, plug wrap, tipping paper, cigarette paper

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FILTER ADDITIVES

Project "Carbo"

Objective : Eliminate MPEG 550, MPEG 750 and PEG 600 in all white and black semi-filters manufactured by FTR and INB.

Status : Two cigarette prototypes BRD and MAK-CH were manufactured at FTR at the beginning of May.

BRD-24P : white-semi : 7% triacetine instead of 10% PZ-8-FI
black-semi : - black tow 5.0Y/35000 instead of 5.0X/40000
- RC333 charcoal quality instead of CFT 136-140
- 4% triacetine instead of 8% CA-INM-FI

MAK-25P : same modifications as on BRD-24P

Both prototypes gave expected smoke deliveries and were evaluated by the EEMA descriptive panel. Positive comments came out especially on the BRD prototype.

Both cigarettes were released mid-May for mail-out tests.
New MAK prototypes were manufactured at the end of June with two different charcoal quantities.

In parallel, first machinability trials were performed at INB on the KDF2/AF2/AC maker using both new tow and charcoal qualities. Difficulties were encountered with the presence of charcoal particles under the seam.

Follow-up: Final results of both mail-out tests will be available by mid-July as well as the descriptive evaluation of the new Muratti KS-CH prototypes. New machinability trials will be done at INB when a modified tongue from Hauni is received.

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

FILTRATION MATERIAL

1. Tow courtaulds 3.0Y/35000

Objective: Qualify this item for Marlboro KS Pan-Europe

Status: Positive results came out from the mail-out test made in Switzerland (D panel) where the MLK prototype using Courtaulds was compared to a standard using Rhodia tow. Three local confirmation tests were made at PMH, PMB and PMG-M. For all tests, we organised local B panels as well as R&D B panels. All six evaluations showed no significant difference between the controls and the prototypes.
The tow from Courtaulds was tested against:

- Eastman at PMG-M and PMH
- Hoechst & Celanese at PMB

Follow-up: Consolidated report of all those tests will be published at the end of July. All factories have been asked now to run small industrial tests with 5 to 10 tons of Courtaulds material.

2. Inter-affiliates collective test with Hoechst & Celanese

Objective: Optimise our current material specifications for tow items.

Status: Capability lines were made in 5 production centres with 4 different items produced at Lanaken.

Item: 3.8Y/37000 - 3.0Y/35000 - 2.5.Y/37000 and 2.6Y/42000.

In addition, all physical tests were also done by all our incoming inspection labs. A similar exercise was already done before by the supplier on the same bales.

Follow-up: In mid-July the program will be completed by making the capability lines at INB. Consolidation of all results will be presented and discussed with all affiliates and the supplier, early October.

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

3. Crepe paper for filters

Objectives: Improve the paper quality delivered by Tela. Check the influence of process manufacturing changes (switch from round table to a flat table).

Status: PMU-CH cigarette prototype was manufactured at FTR using the combi-filter produced at INB with the new material. The test cigarette was approved analytically and tastewise. The industrial test made at INB showed some difficulty in reaching the RTD. All results were discussed at a meeting that took place with the supplier.

Follow-up: New samples are expected beginning of September.

PLUG WRAP PAPER

1. Mauduit PPW 33 (3300 Coresta units)

Objective: Standardise the bobbin winding for all production centres, in order to have the wire side of the paper inside the bobbin.

Status: Two factories (FTR and INB) have already changed and are using now bobbins with the wire side inside.

Follow-up: Three other factories have ordered the material for industrial testing.

2. Mauduit PPW 120 (12000 Coresta units)

Objective: Replace the PPW 140 quality (cost advantages).

Status: Trials made at FTR on the Bond Street family were successful. No difficulties were encountered with all three different types of tipping paper used.

Follow-up: Industrial testing is ongoing at PMH and combi-filters will be manufactured at INB in September to test the "runnability" of the paper.

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

CIGARETTE PAPER

1. Mauduit 165 A (100% wood pulp)

Objective: Qualify a second supplier on the Multifilter family.

Status: This paper has been accepted and is now fully qualified.

TIPPING PAPER (Project "FITIA")

Objective: Improve the gluing of the tipping paper to the filter plug and tobacco rod, on high-speed makers.

Status: A successful test was made at PMG-B on the PMT cigarette using the LS quality from Malaucene.

Follow-up: A confirmation test will be made at PMG-M with the same quality on the PMS cigarette. Another trial will be performed at PMH on Merit 100's with Benkert Blancophan 390 quality.

MATERIAL EVOLUTION - STATUS REPORT NBR. 47/48

Both above-mentioned reports have been published on May 7 and June 26, 1990 by C. Flury.

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

FILTER MANUFACTURING SUPPORT PROGRAM

Objective: Provide technical assistance to the PME factories in order to improve filter consistency and machine efficiency, and to reduce material wastage and manufacturing costs.

Status: Initial discussions took place in all production centres at the end of May with representatives of production, engineering, purchasing and quality assurance.

Consolidated report has been published (ref. 1)

Follow-up: Similar meeting will take place at PM-Spain early July. Official activities with the critical QA methodology group will start in September.

REFERENCE:

1. Filter manufacturing support program / Summary of the initial discussions, by J. Krauss and T. Bel, dated June 27, 1990.

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

RESEARCH AND DEVELOPMENT, NEUCHATEL - QUARTERLY REPORT

DIVISION : MANUFACTURING SERVICES GROUP

SUBJECT TITLE : PRODUCT MODIFICATIONS (LICENSEES)

PERIOD COVERED : APRIL - JUNE 1990

WRITTEN BY : Kopp-A.-M. (AMK)

KEYWORDS : product, specification, monitoring, quality, improvement, implementation, modification, authorised, planned

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OBJECTIVES

To monitor product quality and implement cigarette construction modifications when necessary, in order to ensure that the product quality objectives are met.

PRODUCT MONITORING

A Monitoring Report was issued in June, 1990, covering all Marlboro brands produced by third parties for PM-Europe, as well as Ambassador and Diana cigarettes manufactured in Italy and the major Finnish brands.

Of the 46 brands monitored, 33 (72%) showed smoke deliveries within objectives, 11 had smoke deliveries on the high side and 2 on the low side, mainly concerning smoke nicotine.

Action:

Products on the high side:

ML KS Austria: A change of printed figures on pack has been proposed.

ML 100's Finland:
ML Lights 100's Finland
The blend was slightly modified in May. Moreover, prototypes with a new cigarette paper are being evaluated.

ML KS Hungary: A new ventilated version is being planned. Cigarette prototypes will be made in August.

ML Lights LS Egypt: 100% CF-US replaced 100% BB-US by mid-April 1990. Smoke deliveries of May production were within objectives.

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

Diana KS Rovereto (Italy):
Diana Sp. Mild Bologna (Italy)
Management decision was taken to change neither the specification nor the product. Results obtained for similar products from the Rovereto and Bologna Factories show higher smoke deliveries than those in Verona. This problem is being studied.

L&M LS Finland: Ventilation has been increased twice since January. Analytical results suggest that SN is on target. However, tar tends to be too low. Subject is being reviewed.

Multifilter KS Hungary: Filter construction is planned to be revised.

ML KS Yugoslavia: Blend adjustments are being planned to improve both taste characteristics and delivery numbers.

L&M Lights 100's Hungary: A modified construction is being tested.

Products on the low side:

L&M LS Hungary: A change of SN target has been suggested.

Bond Street KS: Situation is being reviewed with Area Operations Department.

MODIFICATION OF PRODUCTS

Belmont Menthol LS Finland: Cigarette has been redeveloped. The new construction started in May together with the introduction of the mentholated alu foil. First analytical results are within the objectives.

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Source: https://www.industrydocuments.ucsf.edu/docs/fzjl0000

NEW PRODUCTS

ML Lights KS Hungary: This new Light KS soft version started in May 1990. Monthly analyses are not yet available.

Belmont 2002 Menthol LS Finland: This new LS Box cigarette will be launched in October 1990. The product specification is available.

MISCELLANEOUS

Italy: A reduction in cigarette diameter from 7.95 to 7.90mm has been accepted by the Italian Monopoly.

Finland: For cost and quality reasons, ATO will cease in-house printing and electro-perforation of tipping paper. The in-house microlaser perforation will continue.

a.Kopp

References:
- Monitoring Report, by Kopp-A-M., dated June 15, 1990.

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RESEARCH AND DEVELOPMENT, NEUCHATEL - QUARTERLY REPORT

DIVISION : MANUFACTURING SERVICES GROUP

SUBJECT TITLE : EDP APPLICATION FOR PRODUCT SPECIFICATIONS

PERIOD COVERED : APRIL - JUNE 1990

WRITTEN BY : Flury-C. (CAF)

KEYWORDS : edp,application,specifications,mis,focus

OBJECTIVE

Develop an EDP system to manage product specification matters, following the removal of text processing facility 8100 on which product specifications used to be prepared.

The application was intended to support, if possible, speed up, the administrator's specs maintenance tasks. It should provide easy and immediate access to specs data by all collaborators concerned, at all HQ and local functions. Manufacturing Services should be provided with a tool to enable on-line inquiries and write tailored reports of any kind. Further, the application was to be conceived in such a way that it could be compatible with and provide link possibilities to other EDP applications (SPITAB at HQ Lausanne, C.I.R and Monitoring at R&D, etc.).

DEVELOPMENT

Project documentation was prepared and the concept designed during spring and summer, 1989. Presentations were made to persons involved in all production centers and at R&D, and programming started in September, 1989, using SPITAB.

End December, 1989, it was decided to abandon the SPITAB package which did not offer enough facilities for the product specifications. An in-house soft was then set up in three month's time.

Today, 95% of all data are loaded. The system is extremely user-friendly. Most of the working tools are available (FOCUS). All objectives were met or are provided for, except for the direct link to HQ's SPITAB system.

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EXTENT OF APPLICATION

The product specs application covers, from the bottom to the top of the product structure:

Technical Sheets for	filter additives, semisolutions and plasticizers acetate tow, crepe paper plug wraps cigarette logo inks cigarette papers tipping papers
Product Specs for	filter (semis and ready for use) blend (basic data only) cigarettes

The chapter "cigarette" includes a table showing the countries of sale and the figures printed on the packs. It provides for the control of pending modifications (implementation schedule).

STATUS AND OUTLOOK

The display access control system (DACS) will enable giving selective access to the various groups of users, within R&D, the HQ-functions in Lausanne and at production center level.
In addition to the specs administrators, two test persons have presently access to the production system, one MSG-collaborator has access to the production system and to the FOCUS data base.

DACS will be subject to approval by R&D management, who will be given a presentation of the specs application during the second half of August. Other presentations will then follow, at all locations.

C. Flury

CAF/July 06, 1990
qr290specs

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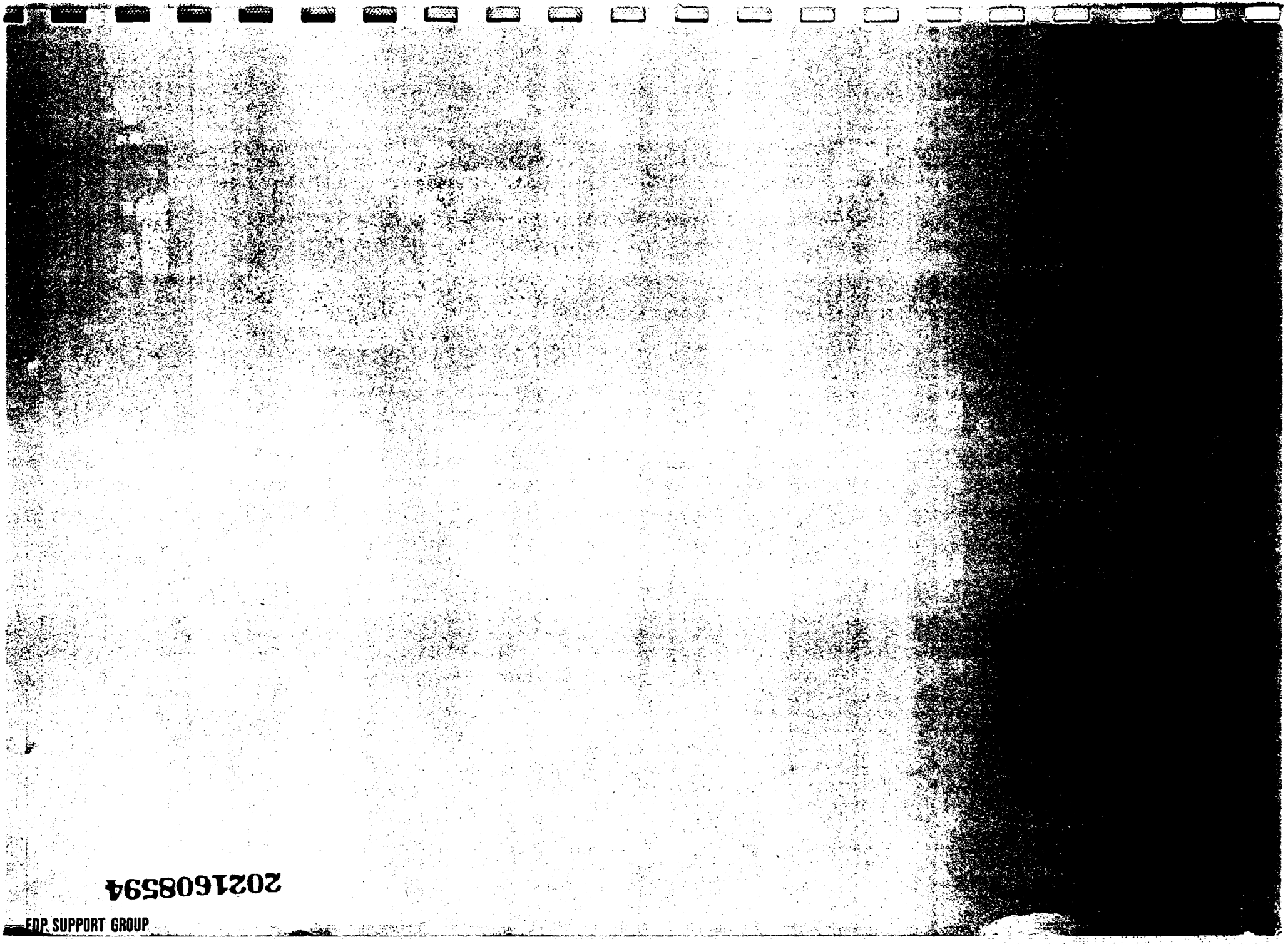

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DIVISION : COMPUTER APPLICATIONS

SUBJECT TITLE : APPLICATIONS AND ACTIVITIES

PERIOD COVERED : APRIL - JUNE 1990

WRITTEN BY : Y. WONG (YIW)

KEYWORDS : Beckman/CALS, digimetry, COLDAC, FOCUS, CSP, FORTRAN, CICS, STAIRS, PROFS, IMP, product specifications, smoking lab, conversion, migration, EDC

MIGRATION / CONVERSION TO EDC (EUROPEAN DATA CENTER)

- R&D System Environment

  The R&D system environment for both CICS/MVS and VM/CMS is in place.

- STAIRS (Storage and Information Retrieval System)

  Significant enhancement is provided in the new version of STAIRS to enable the development of more flexible functions for creation and revision of documents. The current procedures and document-input modules which were developed in the past by FTR/ICS will not be migrated to EDC to be reused. This development is at the final test stage in the R&D CICS production system. A "Front-end" menu for authorized data-base access will be added to STAIRS. The new system is scheduled to be in operation by August.

- VM/CMS Migration

  Migration of EDC to VM/CMS has been completed for SAS (Statistical Analysis System) and for APL, FOCUS, applications.

  Phasing out of ADMCHART utilisation in the FTR mainframe, planned to be completed in July.

  INBIFO VM administration has been transferred to R&D; training/support to INBIFO users is in process.

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- Migration of CICS applications

  Migration of R&D applications has been planned in two phases with the first beginning in March for applications developed with CSP. In the second phase, the remaining applications:

  - Quality Audit / Visual Defects
  - Cigarette Data Bank (CDB)
  - Cigarette Information Report
  - Smoking Panel

  which used to be developed by FTR, will be migrated by FTR/ICS at the end of this year and later reimplemented and upgraded by MIS R&D to support current business needs.

  Migration of CSP applications proceeds as scheduled. All CSP programs have been converted to run in the CICS/MVS system of EDC; COBOL-written printing procedures used in the past are being replaced by batch or CSP procedures. Testing is underway to implement a daily procedure for sending the analytical data of Smoke Lab from the VAX computer to the EDC mainframe via SNA/GATEWAY.

NEW APPLICATIONS FOR PRODUCT / MATERIAL SPECIFICATIONS

FOCUS data base is in place for generation of end-user type monitoring reports.

A list of authorized users from R&D, HQ and affiliates has been established by the Manufacturing Services Group (MSG). Presently, access has been defined to a limited number of users outside MSG, to test their utilization of the system.

Extension of this application to include the Casings and Flavors specifications has been requested by MSG. For decision and timing, Management has been provided with an estimation of the resources necessary for developing an application to replace the current PC system.

SMOKING LAB / QC AUTOMATION

Work planning and resources have been defined for the remaining development in CALS over the next 18 months.

A proposition of CO/NO workpost was made to PMG to use the R&D digimetry solution.

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Links between HP-1000, Digimetry and VAX passing through the NIU/Broadband network, defined and running.

COLDAC SMOKING LABORATORY SYSTEM

Major breakdown of one of the two HP data links. The affected workposts were redirected to the second link. More pressure is being put on the development of digimetry workposts using the broadband network facility to replace the obsolete equipment.

Two digimetry workposts for Firmness/OV measurement have been in operation since April.

Implementation of CO/NO workposts is near completion. Its operation is scheduled for the beginning of July.

PROFS AND VM/CMS DECENTRALIZED ADMINISTRATION

There are now 98 "userids" and 106 "nicknames" in R&D

VM Messenger Software reviewed to replace Telex

VM machine set up to receive HARDCOPY requests from CICS.

Improvement has been made on the R&D VM printing-procedure IMP; this procedure was presented to HQ and affiliates MIS during an EDC workshop on general VM printing, and will be taken as a starting point to create a generalized procedure for all affiliates.

HARDWARE / SOFTWARE - INSTALLED / ORDERED

1 Harvard Graphics software installed
1 LaserJet printer installed
1 IBM-3812 printer installed
1 IBM-3472G terminal installed

Review of new PS/2 software versions for LOTUS 3.0, Harvard Graphics 2.12, VISIO4 2.5.

A TEKTRONICS color jet plotter is in process of being installed in computer-users' room.

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HELP DESK STATISTICS

Number of calls	65
Number of solved problems	60

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